Work Order June-12-13 9:26:4		3090		*103						Page 1			
Revision ID: Item Name: Mo	3461-3 ounting Plate 11/13 11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12 *12		*N900 Cust Item Customer:	ID:	100	ገ* ፡	Setup S	tart Stop	*N!	S1* S2*	
Reference: Approvals: P	Process Plan		Date: 13-02	// Tooling:	D	oate:		. 1	•	start Stop	*N	R1*	
Sequence ID/ Work Center ID		Operation Description	Date:	SPC (Y/N): Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	R2* Insp. Stamp	:
Draw Nbr		ision Nbr											-:
D3461	Rev	A											1
*100 *100* Waterjet FLOW CNC Waterjet	,	FLOW WATER JET Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if	A	0.00			-	14)		Ae	7 - 3
110 *110* QC Quality Control		QC2- Inspect parts off m	nachine FAI/FAIB	0.00				14)_		Ac. 13 16	3 ·3
120 *120*		QC8- Inspect parts - seco	ond check	0.00				<u>(19</u>) <i>Tar</i>	Ōŀ() <u>3</u>	9	AS 9 89

Quality Control

DQA:			Date: WORK ORDER NON-CONFORMANCE / UPDATE						DART				
QA Closed:			Date:			WORK ORDER NON-	-CC	DNFO	RMANCE / UI		Vork Order u	ndate only	AEROSPACE
Q. C.			Dute.			DISPOSITION				••			
Work Orde	er:					DISPOSITION				AGAINST	EPARTMENT	/PROCESS	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thermoforming Finish			Rec/Sto	re/Packaging Supplier	Other
NCR N	10		*····			Suspected Unapproved		Large Fab Composi					
Root					Desci	ription of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	_												
Handling/Pre	_												
Material	_												
Operator													
Offset/Setup													
Process	_												
Supplier	_					_							
Training	_												
Transport	_									٠.			
Unapproved	\perp												
							FA	ULT CAT	regory				<u> </u>
Landir					_	General		1		_			, ¬
	_	ending	_		<u> </u>	Bend	<u> </u>	1	rogram	_	Outside Dim	 	Pressure/Forced
	_		t Concer	ntric		BOM/Route		Grain			Over/Under		Set-up
	_	racks			-	Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorre	 	Temperature/Cure
}				Burrs	<u> </u>	1	ion Incomplete/Ur	· -	Part Lost/M		Weld		
	Cuffs			-	Contamination	_	4	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled	
		rushing				Countersink		1	ned/off center	L	Positioned \	_	7
	\blacksquare	eat Trea			·	Cut Too Short		Mislabe		L	Power Loss	/Surge	Other
	_	•	Strip in	Tube	_	Drawing		Misread	d				
	\blacksquare	larks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set					
	_	•	equence		<u> </u>	Finish	<u> </u>	4	Calibration		**		
	Wave/Twist in Tube			- 1	Fit/Function	1	Out of 9	Seguence					

Work Ord June-12-13 9:2		03090		*103					Page 2			
Item ID:	D3461-3			Accept	*N900	በፈበ	100	ገ*	Setup	Start	*\	S1*
Revision ID:					14.5/(// /	·		•		C.		
Item Name:	Mounting Pl	ate								Stop	*N:	S2*
Start Date:	6/11/13	Start Qty: 12.00	*12*		Cust Item I	D:						
Required Date	: 6/11/13	Req'd Qty: 12.00	*12*		Customer:							
Reference:			17									
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:			Run	Start	17	R1*
	QC:		Date:		Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	T D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt		Reject Number	Insp. Stamp
130		Small Fab		0.00								19
Small Fab		Memo		0.00								
Small Fab		Deburr parts	per dwg D3461		NA	\AS 19	}					19 19 14.01.00
140		QC5- Inspect part comple	eteness to step on W/O	0.00	,	9-89						
1 <i>4</i> ∩					1							
QC		Memo		0.00								
Quality Control												•
150		Identify as per dwg & Sto	ock Location: WH, E	0.00				;,/		d		
150 Packaging		Memo		0.00				14		Ψ		1/21/05
Packaging			IN STEP CELL***							/		14.01.00

Packaging

DQA:	Date:							TAART					
QA Closed:			Date:			WORK ORDER NON-	-CC	AEROSPACE					
						DISPOSITION				AGAINST DE	ork Order up	<u> </u>	
Work Orde	er:					DISPOSITION				AOAIII DE		, , NOCE33	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	Ю.					Scrap			Machining	Small Fab	-	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	Other	
NCR N	۱o. _.					Suspected Unapproved Large Fab		Large Fab	Composite[Supplie			ا لـا	
Root					Desc	ription of work order update		nitial	Actio	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling												:	
Handling/Pre						•							
Material													
Operator	\Box												
Offset/Setup							1						
Process						•							
Supplier							Ì		į				
Training													
Transport	,												
Unapproved				<u> </u>	<u> </u>								
l andi							FA	ULI CA	TEGORY				
Landi	ng c	Bending				General Bend	_	ارمانه را	Program	_	Outside Dim	ansions [Pressure/Forced
		Centre No	ot Concor	ntric	\vdash	BOM/Route	\vdash	Grain	riograffi	<u> </u>	Over/Under		Set-up
		Cracks	ot concer	itiic	-	Broken/Damage/Defect	-	Hardwa	aro.	-	Part Incorred	-	Temperature/Cure
	\vdash	Crimp/Kir	nk/Rinnla	/\ <i>M</i> /2\/0		Burrs	\vdash	1	ion Incomplete/Unq	nualified	Part Lost/Mi	· · ·	Weld
	_	t i	my mppie	, wave		Contamination	\vdash	1	tions Incomplete/Un	· —	Part Moved	133111g	Wrong Stock Pulled
,	Crushing			<u> </u>	Countersink	-	4	gned/off center	lcieai	Positioned V	Vrong	Twiton's stock railed	
	Crushing Heat Treat				Cut Too Short	<u> </u>	Mislabe	="	<u> </u>	Power Loss/	_	Other	
	H	Inspectio		Tube	\vdash	Drawing		Misrea		<u> </u>	J. 044Ci 1033/		Louici
	H	Marks/Ch	•			Drill Holes	 	Off-set					
	\vdash	1				Finish		4	Calibration				
	Turning Sequence Wave/Twist in Tube				Fit/Function		1	Sequence					
	Wave/Twist in Tube												

Work Order ID 103090 *103090* Page 3 June-12-13 9:26:49 AM Item ID: D3461-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Mounting Plate **Start Qty: 12.00 Start Date:** 6/11/13 **Cust Item ID:** Required Date: 6/11/13 Req'd Qty: 12.00 **Customer:** Reference: Run Tooling: Date: Approvals: Process Plan: Date: Stop Date: SPC (Y/N): Date: QC: Tool # Plan Reject Reject Tool ID Sequence ID/ **Operation** Set Up/ Accept Insp. Work Center ID Code Description **Run Hours**

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

Quality Control

160

160

QC

ccept Rejenty Qty Number 14-01-8

M/4-01-8

M/4-01-8

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:			WORK ORDER NON-	AEROSPACE						
Work Orde	ar:					DISPOSITION			Α	AGAINST DE	PARTMENT/	PROCESS	
WOIK OIGE	=1·					Rework			Skid-tube Cr	rosstube]	Water Jet	Engineering
Part N	١n					Scrap		1	—	mall Fab	Pro	d. Eng. Coor.	Quality
, are i	···					Use-as-is			Ÿ 	inishing	4	e/Packaging	Other
NCR N	No.					Suspected Unapproved		,,,,	~ 	mposite	1100,000	Supplier	
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Root					Desc	ription of work order update	ı	nitial	Action		Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	QC Inspector
Design						·					•		
Doc/Data		}											
Equip/Tooling													
Handling/Pre	Ш												
Material		1											
Operator													
Offset/Setup													
Process	Ш											i	
Supplier													
Training													
Transport													
Unapproved													
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Landi	ng Gear				r	General		1 .		_	1	_	7
	\vdash	ding			<u> </u>	Bend	<u> </u>	1	Program		Outside Dim	 	Pressure/Forced
	\vdash	tre Not	Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	-	Set-up
	Crac				<u> </u>	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	}	Temperature/Cure
	_	np/Kink,	/Ripple,	/Wave	_	Burrs	<u> </u>	1	ion Incomplete/Unquali		Part Lost/Mi	ssing	Weld
	Cuff				<u> </u>	Contamination	<u> </u>	ł	tions Incomplete/Unclea	ar	Part Moved	L	Wrong Stock Pulled
	-	shing				Countersink		1	gned/off center		Positioned V	_	7
	${f -}$	t Treat			\vdash	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other
	_ `	pection S		Tube	<u> </u>	Drawing	\vdash	Misrea					
		rks/Chat				Drill Holes		Off-set					
	\vdash	ning Sec			<u> </u>	Finish	<u> </u>	1	Calibration				
	I IWa	ve/Twis	t in Tuh	e	ı	Fit/Function	1	Out of	Seguence				

June-12-13 9:26:49 AM

Work Order ID:

103090

Parent Item:

D3461-3

Parent Item Name:

Mounting Plate

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV. A 05.12.13 NEW ISSUE

EC IPP Rev:B Now On Watejet 07-06-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.000		Purchased	No			100	f	122.8400	0.17	2.1473688	3		
6061-T6 Bar .187 x 4.00													

Location Loc Qty Loc Code MAT051 122.84 123279 22.84 100 125590

125590 -> 2.14

DQA:			Date:			MODE ODDED NON	~		DRAANICE / LL	DDATE					
QA Closed:			Date:			WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AEROSPACE
Mork Orda	· ·					DISPOSITION				AGAINST D	EPAR	MENT	/PROCESS		
Work Orde	er				-	Rework	ļ	!	Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	No.					⊢	Scrap Machining Small Fab				-	Pro	d. Eng. Coor.	\dashv	Quality
, 4, , ,	··-					Use-as-is			noforming	Finishing	\dashv R		re/Packaging	\dashv	Other
NCR N	No		8.1 18.1			Suspected Unapproved		 :	Large Fab	Composite			Supplier		
		-						*** 1		.•	1 6:		<u> </u>		
Root		D - 4 -	Chan		Desci	ription of work order update		nitial .		tion	- 1	gn &	\		061
Cause		Date	Step	Qty		or non-conformance	Cn	ief Eng	Desci	ription	- 1	ate	Verification	n	QC Inspector
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Doc/Data Equip/Tooling	\forall										1			- 1	
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Unapproved						·								Ì	
							FAL	ULT CAT	TEGORY						
Landi	ng Gea	ar				General				_					
	Ве	ending				Bend		Folio/F	rogram		Outs	ide Dim	ensions		Pressure/Forced
	L_C€	entre No	ot Concer	ntric		BOM/Route		Grain			Ove	/Under	tolerance		Set-up
	☐ Cr	acks				Broken/Damage/Defect		Hardwa	re		Part	Incorre	ct		Temperature/Cure
	Cr	imp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part	Lost/Mi	issing		Weld
	Cuffs			Contamination		ł	ions Incomplete/	Unclear	_	Moved			Wrong Stock Pulled		
	Crushing			Countersink		•	ned/off center	L		tioned V	· ·	,,			
	Heat Treat Cu			Cut Too Short		Mislabe		L	Pow	er Loss/	Surge		Other		
	-		n Strip in	Tube		Drawing		Misread	t						
	\vdash	arks/Ch				Drill Holes		Off-set							·
			equence			Finish	L	1	Calibration						
	Wave/Twist in Tube			- 1	Fit/Function	1	Out of	Sequence							

D3065-5DART AEROSPACE LTD	Work Order:	103 590
Description: Mounting Plate	Part Number:	D3461-3
Inspection Dwg: D3461 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	,257	-		V	JKm = 5
2.846	+/-0.010	2.846	_		٧	
0.761	+/-0.010	.761	•		V	
1.121	+/-0.010	1.121			V	
R0.125	+/-0.010	125	_		V	
				-		
	-					
			DAS			

		Q				
Measured by:	Audited by:	9-89	Prof	otype Approval:	N/A	
Date: 13 · 12 · 30	Date:	14.01.03		Date:	N/A	

Rev	Date	Change	Revised by	Approved
Α	06.12.07	New Issue	KJ/JLM A	E
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	11 Jane	Beauting .				

1.101

S 41.14

D3461-5/-7 MOUNTING PLATE

- 1.337

Ø0.257 (TYP)

MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188)

NONE FINISH:

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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R0.386

(TYP)

0.586

2.715

D2622 **EXTRUSION** PROFILE

D3461-5 MOUNTING PLATE

pl306h

R0.386

(TYP)

0.586

R0.125

(TYP)

0.889

Ø0.257

(TYP)

R_{0.125}

(TYP)

2.715

D2622

EXTRUSION

PROFILE

D3461-7 MOUNTING PLATE

1.337 --